

Claims

1. A method for producing a printed product, with the steps of:

- a) unrolling a web (04) of material from a first roll (02),
- b) imprinting the web (04) of material,
- c) winding the imprinted web (04) of material up into a new roll (12),
- d) unwinding a first imprinted web (16a) of material from a roll (12a),
- e) unwinding a second imprinted web (16b) of material from a further roll (12b),
- f) bringing the two webs (16a, 16b) of material together in a superstructure (17),
- g) separating the webs (16a, 16b) of material each into several partial webs (19a, 19b),
- h) mixing the partial webs (19a, 19b) by means of a turning bar arrangement (21),
- i) longitudinal folding of the mixed partial webs (19a, 19b),
- j) transverse cutting and transverse folding of the partial webs (19a, 19b).

2. The method in accordance with claim 1, characterized in that the steps a) to c) are performed at a higher speed of the web (04) of material than the steps d) to j).

3. A further processing device of a web-fed printing press with the following characteristics:

- a) several roll changers (13a, 13b) for unwinding imprinted webs (16a, 16b) of material are arranged,
- b) a draw-in unit (14a, 14b) is arranged downstream of each roll changer,
- c) a longitudinal cutting device (18a, 18b) for cutting the webs (16a, 16b) of material into partial webs (19a, 19b) of material is arranged directly after the draw-in units,
- d) a turning bar arrangement (21) is provided downstream of the longitudinal cutting device (18a, 18b),
- e) at least one former (24, 26), one transverse cutting device and at least one transverse folder (22, 23) are arranged downstream of the turning bar arrangement (21).

4. An installation for producing printed products with the following characteristics:

- a) a web-fed rotary printing press with a roll changer (01), several print units (07) and a re-reeling device (11) is arranged,
- b) a further processing device with at least one roll changer (13a, 13b), a superstructure (17), at least one former (24, 26) for longitudinal folding and at least one folder (22, 23) for transverse folding are arranged,
- c) the web-fed printing press and the further processing unit are arranged in a common building.

5. The method in accordance with claim 1 or the further processing device in accordance with claim 3 or the installation in accordance with claim 4, characterized in

that a web (16a) of material is separated into two partial webs (19a).

6. The method in accordance with claim 1 or the further processing device in accordance with claim 3 or the installation in accordance with claim 4, characterized in that a web (16b) of material is separated into three partial webs (19a).

7. The method in accordance with claim 1 or the further processing device in accordance with claim 3 or the installation in accordance with claim 4, characterized in that the two partial webs (19a) each have a width of two pages.

8. The method in accordance with claim 1 or the further processing device in accordance with claim 3 or the installation in accordance with claim 4, characterized in that the three partial webs (19b) have a width of two pages, and the two other partial webs (19b) each have a width of one page.

9. The method or the further processing device in accordance with claim 5 or 6, characterized in that each page corresponds to a newspaper page.

10. The further processing device in accordance with claim 3 or the installation in accordance with claim 4, characterized in that the web-fed printing press and the further processing device are arranged side-by-side.

11. The further processing device in accordance with claim 3 or the installation in accordance with claim 4, characterized in that the web running direction of the roll changers (01) of the web-fed printing press and the roll changers (13a, 13b) of the further processing device extend in parallel.

12. The further processing device in accordance with claim 3 or the installation in accordance with claim 4, characterized in that the web-fed printing press has a dryer (08) on a path of the web (04) from the print units (07) to the re-reeling device (11).

13. The further processing device in accordance with claim 3 or the installation in accordance with claim 4, characterized in that the web-fed printing press has a cooling roller arrangement (09) on a path of the web (04) from the print units (07) to the re-reeling device (11).

14. The further processing device in accordance with claim 3, characterized in that it has a former (24) centered on the web (16a, 16b) which is not longitudinally cut, and at least one former (26), which is centered on one of the partial webs (19a, 19b).

15. The method in accordance with claim 2 or the further processing device in accordance with claim 3 or the installation in accordance with claim 4, characterized in that the web speed of the web-fed rotary printing press is at

least 30% greater than the web speed of the further processing device.

16. The method or the further processing device or the installation in accordance with claim 15, characterized that the web speed is respectively of the maximum production speed.

17. The further processing device in accordance with claim 3, characterized in that the two roll changers (13a, 13b) each have their own position-controlled electric drive mechanism.

18. The further processing device in accordance with claim 17, characterized in that a control device controls these electric drive mechanisms in such a way that successive identical print images on the two webs (16a, 16b) of material agree or have a constant spacing, i.e. maintain registration.

19. The method in accordance with claim 1, characterized in that the imprinted rolls (12a, 12b) have each been produced by a 16-page printing press.

20. The method in accordance with claim 1, characterized in that a 32-page printed product is produced.

21. The further processing device in accordance with claim 3, characterized in that the web-fed printing press is a 16-page printing press.

22. The further processing device in accordance with claim 3, characterized in that the created printed product has 32 pages.

23. The further processing device in accordance with claim 3, characterized in that the printing press is embodied as a jobbing printing press.